

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005539**Date Inspected:** 03-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yan hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG CSD / SSD**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # Open Yard

The QA Inspector performed initial random visual inspections of closed rib stiffener welds on deck panel DP138-001, DP111-002 & DP084-001. The QA Inspector observed ZPMC and ABF representatives had completed visual inspections of these welds and they had identified portions of the welds that need rework. The initial inspections have been documented on the bottom of the yellow inspection status tag that is attached to the deck panel. The QA Inspector completed the initial visual inspections of the welds on this deck panel and documented the initial visual inspections on the bottom of the yellow inspection status tag that is attached to the deck panel.

OBG # Segment 3AW

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as CSD / SSD. The weld designations reviewed are as follows:

(SSD10-PP020-039,040,041,042,043,044,081,082,083,084,110,11,112,113)

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(SSD10A-PP020-074,075,076,077,016,017,018,019,020,021,036,037,038,039,040,041)

(CSD3-PP020-069,071,067,112,114)

(CSD3-PP020-066,067,068,070) – Reject able Indication found by MT method.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

The QA Inspector informed ZPMC QC CWI Mr. Li yan hua that the QA Inspector performed magnetic particle inspections of welds CSD3-PP020-066, CSD3-PP020-067, CSD3-PP020-068 and CSD3-PP020-070 that Four welds have linear indications. The QA Inspector informed Mr. Li yan hua that the QA Inspector will be issuing an incident report to document that ZPMC had accepted these welds which have linear indications.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
